

DART SERVICE INSTRUCTION

TO AMEND

INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D350-748 Rev. 1

REF. CANADIAN STC: SH06-27

REF. FAA STC: SR02359NY

REF. EASA STC: EASA.10016903

PURPOSE:

For D350-748-101/-201 High Crosstubes at CHG 003 or later, the D2856-400-710 Abrasion Strips have been removed and the D3502-1 Supports have been installed with Proseal 890.

CHANGE:

The parts list in Section 32.8 of ICA-D350-748 Rev. 1 is updated as follows:

32.8 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT

WAS

*2	*2	D2856-400-710	ABRASION STRIP
*2	*2	MS21920-20	CLAMP

IS:

*2	*2	D3595-063-395	RUBBER CUSHION
*2	*2	MS21920-22	CLAMP (OR MS21920-21)
*A/R	*A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

The support installation procedure in Section 32.4 of ICA-D350-748 Rev. 1 is updated as follows:

32.4 SUPPORT INSTALLATION

Note: If installing supports on D350-748-101/-201 at CHG 002 or earlier, it is recommended that the D2856-400-710 Abrasion Strips at the support locations be removed in accordance with Section 32.5 of ICA-D350-748 Rev. 1 and the supports be installed as outlined below.






- 32.4.1 Locate the area on the crosstube for installation of support (see Figure 1 of this service instruction). Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.2.12) of ICA-D350-748.
- 32.4.2 Abrade the mating surface of support with 180-grit sandpaper. Abrade the mating surface of the crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Apply a 0.02" to 0.05" thick layer of Proseal 890 Class B or AMS-S-8802 Class B sealant underneath applicable support and install support as shown in Figure 1 of this service instruction.
- 32.4.4 Install the clamps on support as shown in the section A-A of Figure 1 of this service instruction. Install rubber cushions underneath each clamp around the bottom circumference of the crosstube up to the crosstube centerline. Torque clamps 60-80 in-lb (6.8-9.0 Nm). It is acceptable to use smaller or larger sized MS21920-XX clamps; ensure that the nuts are in safety but not bottomed out after torquing the clamps per this instruction.
- 32.4.5 Prior to installing crosstube on aircraft, allow supports to cure for 72 hours and recheck torque on clamps.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.10.10
CERT. NO.: SH06-27
ISSUE NO.: 2

A	NEW ISSUE	CP	12.10.10
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9634	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT INSTALLATION CHANGE	NTS
DATE	12.10.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

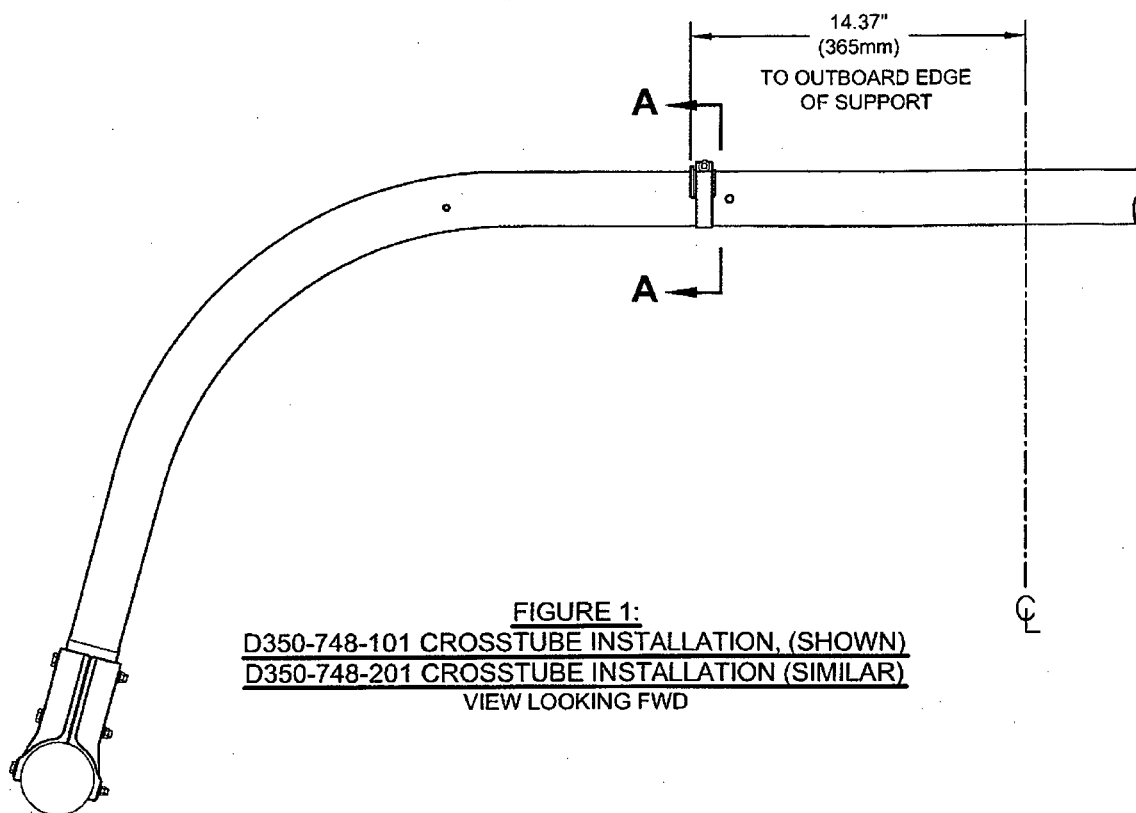
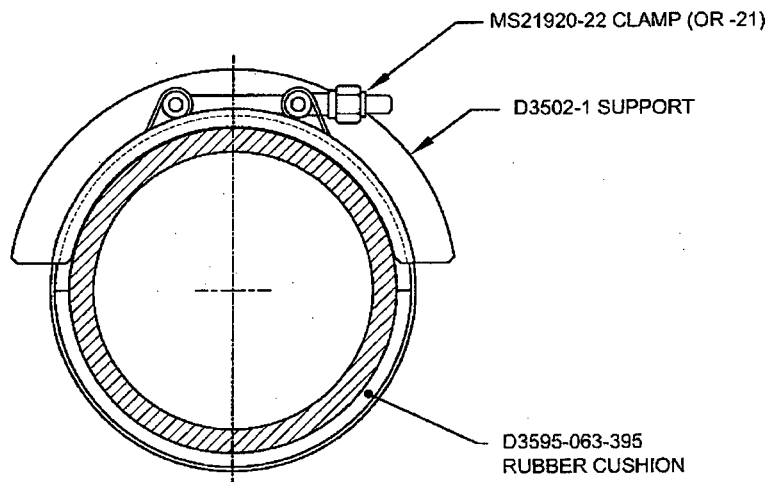


FIGURE 1:
D350-748-101 CROSSTUBE INSTALLATION, (SHOWN)
D350-748-201 CROSSTUBE INSTALLATION (SIMILAR)
VIEW LOOKING FWD








SECTION A-A
SCALE 6X

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED
 BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 12.10.10
 CERT. NO.: SH06-27
 ISSUE NO.: 2

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9634	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT INSTALLATION CHANGE	NTS
DATE	12.10.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			